

Work Order ID 163821

Monday, July 10, 2017 11:55:46 AM

163821

Page 1

Item ID: D3281-4L08

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector, Aft RH

Start Date: 7/12/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 4.00

4

Customer:

Reference:

DAS

Approvals:

Process Plan:

13
9-89Date: **JUL 11 2017**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3281	Rev F								

110

0.00

110

THERMOFORMING MACHINE

Purchasing

Memo

0.00

Purchasing

ISSUE P/O: 37042
SUPPLIER: PLASTECB

MANUFACTURE D3281-4L08 AS PER DWG

C OF C IS REQUIRED

DAS
13
9-89QRB 12/07/13

140

0.00

140

Receive & Inspect for Damage & Mat'l Certs

HAND FINISHING THERMOFORMING

Packaging

Memo

0.00

Packaging

4x SP 17-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Monday, July 10, 2017 11:55:46 AM

163821

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Item ID:	D3281-4L08	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Floor Protector, Aft RH				Stop	*NS2*
Start Date:	7/12/2017	Start Qty: 4.00	*4*	Cust Item ID:		
Required Date:	7/21/2017	Req'd Qty: 4.00	*4*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC6- All purchased or subcontracted products	0.00					
150							
QC	Memo	0.00					
Quality Control							

POSITIVE RECALL
JUL 11 2017
EFFECTIVE AUTH PD
RELEASED PD DATE 17-09-20

170	Identify as per dwg & Stock Location: <u>5615</u>	0.00
170		
Packaging	Memo	0.00
Packaging		

4 5615 SEP 20 2017

180	QC21- Final Inspection - Work Order Release	0.00	<u>17/9/21</u> 
180			
QC	Memo	0.00	
Quality Control			

SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
RELEASED DATE _____ EFFECTIVE DATE _____ AUTH _____ POSITIVE RECALL								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 163821

163821

Parent Item: D3281-4L08

D3281-4I 08

Parent Item Name: Floor Protector, Aft RH

Start Date: 7/12/2017

Required Date: 7/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL
IPP Rev.C 17.06.13 Now outside process DP Verify DD

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3281-4L08P		Purchased	No			110	Each	0.0000	1	4			
D3281-4I 08P									**				
Floor Protector, Aft RH													

4x50779-12.

DQA: _____ Date: _____



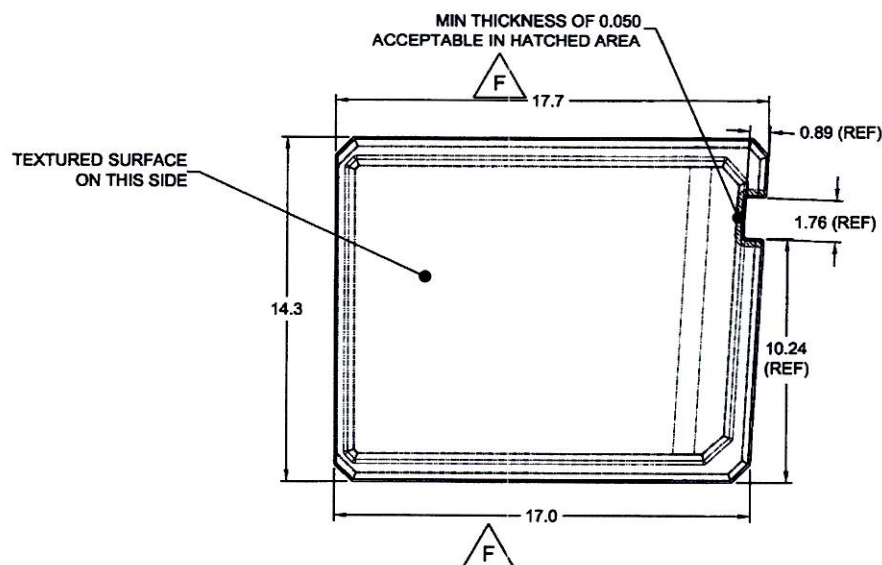
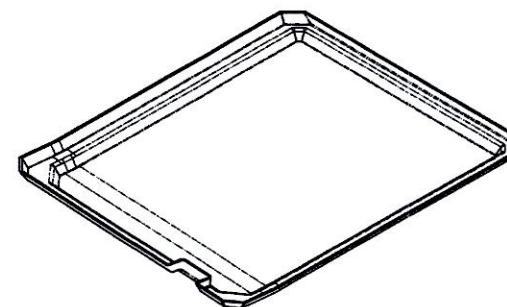
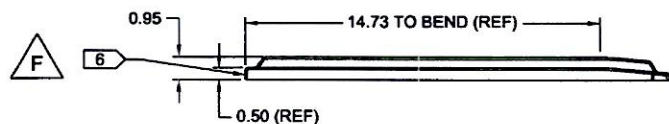
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER :							
Misidentified	☐	Past Due								



D3281-4 FLOOR PROTECTOR

DAS
13
9-88

JUL 11 2017

W10: 163821

RELEASE
2010-11-25

D3281-4 NOTES:

- 1) MATERIAL: -4L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-4L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFICATION: IDENT WITH DART P/N "D3281-4Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-4L02 = 0.87 lb D3281-4L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3281	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37042**

Purchase Order Date 7/13/2017

PO Print Date 7/19/2017

Page Number 2 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D3281-3L08P	Floor Protector, Aft LH	8/3/2017	4.00	\$100.00	\$400.00
			Yes	Each		
			8/3/2017			

As per dwg D3281
REV. F
B163831

Line Total: \$400.00

4	D3281-4L08P	Floor Protector, Aft RH	8/3/2017	4.00	\$100.00	\$400.00
			Yes	Each		
			8/3/2017			

As per dwg D3281
REV. F
B163831

PD
17.2925

SP-9-12

Line Total: \$400.00

Note:

7/19/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P: 416 736 0004
F: 416 736 0010

Shipment Number: 24291
Shipment Date: 09/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37042
Carrier Account #

Sales Order
SO-019296

Ship Via
FREIGHTCOM INC. -

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number
01249377972

Item Number - Revision Description

D3281-1L08P - Rev.: F FLOOR PROTECTOR, FWD LH
AS PER DWG D3281 REV. F B163812
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D3281-2L08P - Rev.: F FLOOR PROTECTOR, FWD RH
AS PER DWG D3281 REV. F B163792
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

D3281-3L08P - Rev.: F FLOOR PROTECTOR, AFT LH
AS PER DWG D3281 REV. F B163831
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

✓ D3281-4L08P - Rev.: F FLOOR PROTECTOR, AFT RH
AS PER DWG D3281 REV. F B163821
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

4 EA

4 EA

4 EA

4 EA

FREIGHT -

FREIGHT

1 EA

PD
SP17-9-12

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance

Customer: DART AEROSPACE LTD P.O. # 37042 SO # 019296

Part #	D3281-1L08P	Qty.	4	Batch #	-001
Description	FLOOR PROTECTOR, FWD LH	Material usage	1 SHEET	Lot#	M138294
Part #	D3281-2L08P	Qty.	4	Batch #	-002
Description	FLOOR PROTECTOR, FWD RH	Material usage	OFFCUT	Lot#	M138294
Part #	D3281-3L08P	Qty.	4	Batch #	-003
Description	FLOOR PROTECTOR, AFT LH	Material usage	OFFCUT	Lot#	M138294
Part #	D3281-4L08P	Qty.	4	Batch #	-004
Description	FLOOR PROTECTOR, AFT RH	Material usage	OFFCUT	Lot#	M138294
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT. 7, 2017 COFC# 008
(Approved QA Signatory)

Page: 1 of 1

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, Aft RH		Part Number:	D3281-4
Inspection Dwg: D3281	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DAS 07 9-89	Date:	17/09/14
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.7"	✓			
17.1	+/-0.100	17.0"	✓			
14.3	+/-0.100	14.25"	✓			
0.95	+/-0.030	0.96"	✓			
0.050	Min	0.077"	✓			
0.070	Min	0.097"	✓			

Measured by:	DAS 07 9-89	Date:	17/09/14
Audited by:	PD	Date:	17.09.20
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	10.09.01	Dimensions updated per Dwg Rev E	KJ	
D	11.06.21	Dwg Rev updated	KJ	



PLAS-TECH
Think Plastics™

Rev.	Date	Change	Revised by	Approved